

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002362**Date Inspected:** 18-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

The QA Inspector observed Z. P. M. C. welder Yang Lei, ID #040690, air arc weld number MUSA-SA95-15, and the QA Inspector was told that WPS-345-2G (2F)-FCM-Repair and WPS-345-SMAW-3G (3F)-FCM-Repair, will be used, in accordance with Critical Weld Repair (CWR) number 036. After the completion of the air arcing, the weld was ground. Z. P. M. C. Quality Control (QC) personnel then did a Magnetic Particle Test (MT), which was witnessed by the QA inspector. The weld was found to be in compliance with the Contract Documents.

The QA Inspector observed Z. P. M. C. QC personnel perform an MT on the machined ends of five (5) welded bolt splice connection splices, the drilling of bolt holes in bolt splice connection plates, and Z. P. M. C. personnel remove cut diaphragm plates from Bay 2 and take them to Bay 9.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

The QA Inspector had no substantial conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
